

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002022**Date Inspected:** 15-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|----------------------|----|-----|
| CWI Name: | No welding performed | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | |
|----------------------------------|-----|----|
| CWI Present: | Yes | No |
| Rod Oven in Use: | Yes | No |
| Weld Procedures Followed: | Yes | No |
| Verified Joint Fit-up: | Yes | No |
| Approved WPS: | Yes | No |
| Delayed / Cancelled: | Yes | No |

Bridge No: 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

114-meter Mock-Up, Z. P. M. C. personnel drilled bolt holes in bolted splice connection plates.

114-meter Mock-Up, upper section. Z. P. M. C. personnel attached and temporarily bolted the exterior bolted splice connection to the exterior of Skin C. After tightening of the installed bolts there is a gap on one side, between the exterior splice connection plate and Skin "C". The welded splice connection plate was then attached. The welded splice plate was aligned using bull pens. Note: the outside diameter of the bull pen is the same diameter as the interior diameter of the drilled bolt holes. This could result in the "rounding" of a section of the drilled bolt holes. When the welded splice plate is aligned and bolted in place, there is 3 millimeters (mm) of mismatch between it and the internally welded splice plate.

114-meter Mock-Up, the Mock-Up is relocated and rotated, and moved adjacent to the 114-meter Mock-Up, lower section.

Bay 8) Cut diaphragm plate numbers SA326, SA27, Plate 632, Plate 459, Plate 207, SA335, Plate 249, Plate 47, Plate 775, Plate 54, Plate 248, Plate 459, and two (2) unidentified Plates.

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Summary of Conversations:

The QA Inspector had no significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Stovall,Paul | Quality Assurance Inspector |
| Reviewed By: | Cochran,Jim | QA Reviewer |
